



Date: Monday, 25/09/2006 11:02:51 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW
Job Number	: 28715		
Estimate Number	: 11647		
P.O. Number	: N/A	Part Number	: D2995
This Issue	: 25/09/2006 S.O. No. : N/A	Drawing Number	: D2995 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: N/A	Material	: N/A
Written By	: 	Due Date	: 02/10/2006
Checked & Approved By	: 	Qty:	6 Um: Each
Comment	: Est A 01.03.07 New Issue EC		

(3 sets)

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 2.7777 sf(s)/Unit Total : 16.6662 sf(s)

Pick:

Material: Black UHMW 1"

Batch 102164

M100501 +1

J.F. 06/09/25

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Cut blank: 19.50" x 20.00"

Inspect material for defects or damage prior to machining

Machine as per folio FA119

Deburr

En J.F. 06/09/25

PTD

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En J.F. 06/09/25

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 06/09/27

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock 0500570-13

Location: _____

164/9/27 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/09/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/26	# 20	one part has a small medium mark in the left lower Pocket	CP 06.09.27 PV QSI 142	Replace Scrap Part	CP 06/09/26	2 06-09-27	CP 06.09.27 PV QSI 042	2 06-09-26

NOTE: Date & initial all entries

Date: Monday, 25/09/2006 11:02:51 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 28715

Part Number: D2995

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

206/09/28

Job Completion



U 0609-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

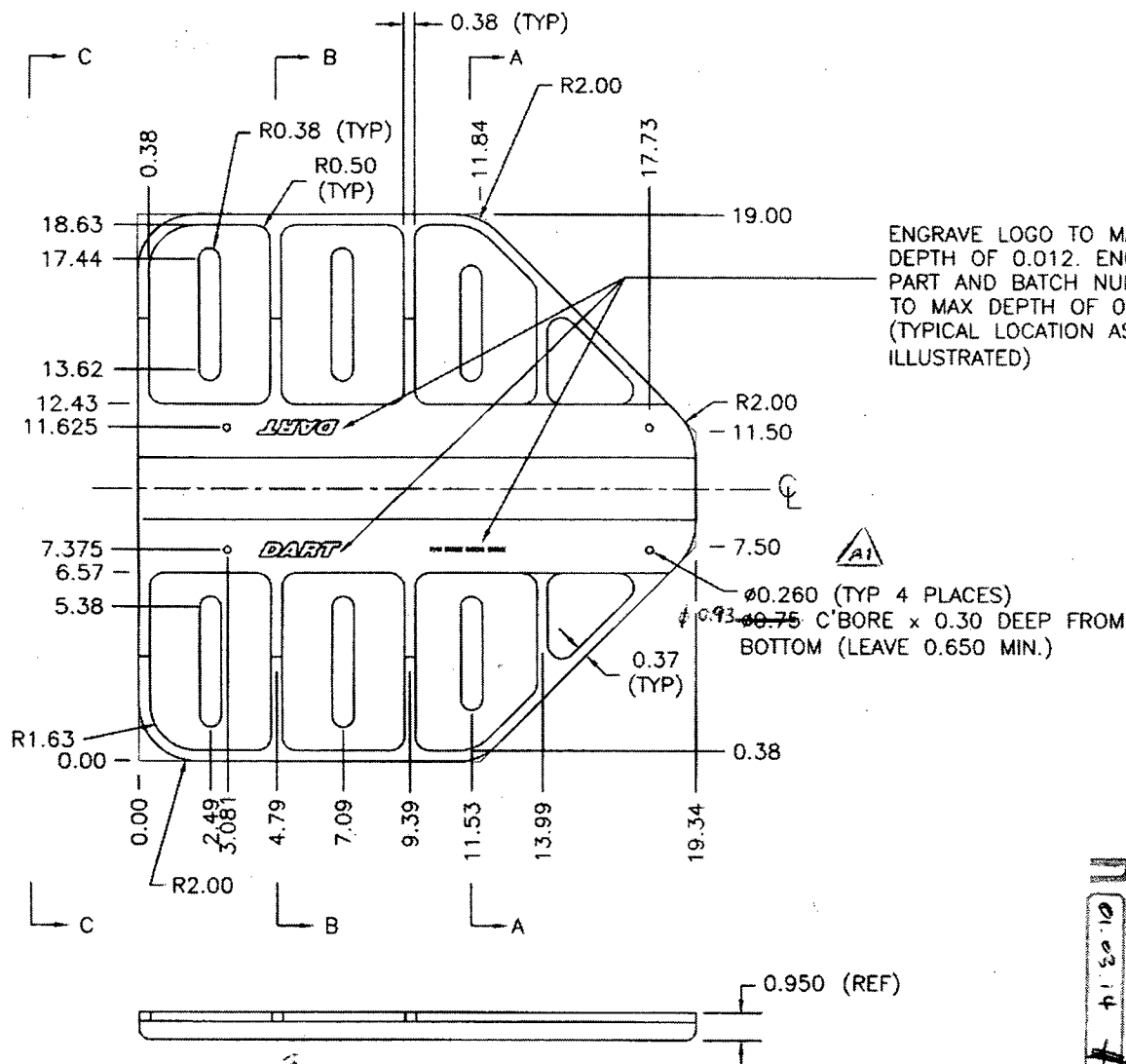
DART



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	01.02.23	TITLE	D2995	REV. A
			BEARPAW	SHEET 1 OF 2
			NEW ISSUE	SCALE 1:6
AI	<i>[Signature]</i>	03.01.06	0.0.3 was 0.0.75	

RELEASED
01.03.14

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

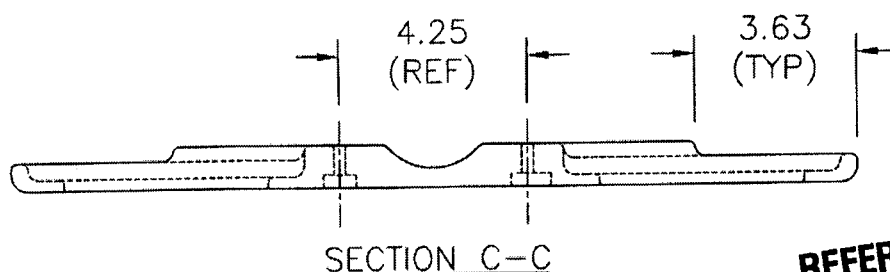
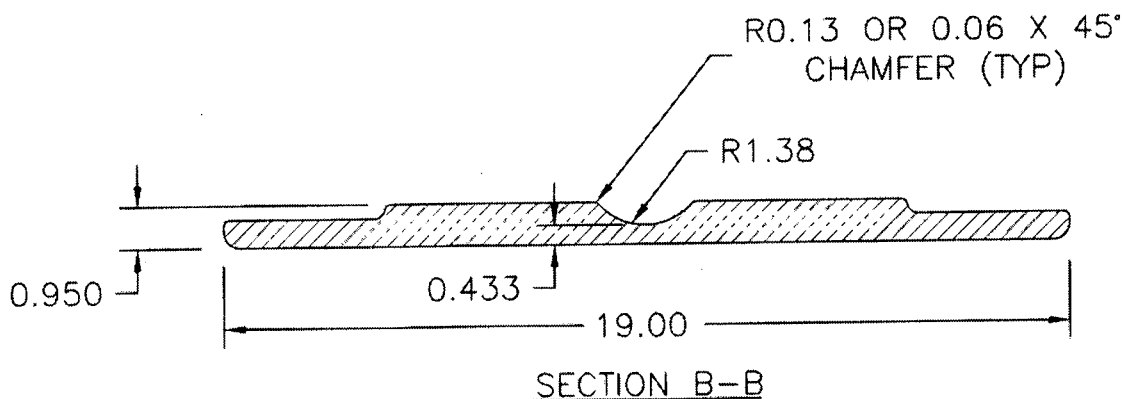
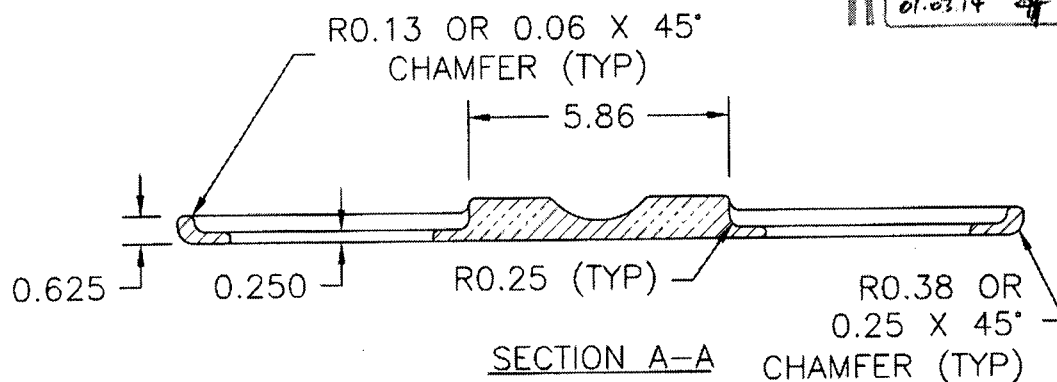
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2995	REV. A SHEET 2 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:4

RELEASED
01.03.14 *A*



REFERENCE ONLY

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 28715
Description: BEAR PAW		Part Number: D2995
Inspection Dwg: D2995, Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	± 0.010	0.630	✓		VCM	
0.250	± "	0.247	✓		"	
2.025	± 0.030	0.25	✓		R-G	
0.25 x 45°	"	0.267 x 45°	✓		VCM	
5.86	± 0.030	5.859	✓		"	
0.950	± 0.010	0.948	✓		"	
0.433	"	0.438	✓		"	
19.00	± 0.030	19.00	✓		TAPE MEASURE	
4.25	"	4.248	✓		VCM	
3.63	"	3.632	✓		"	
7.375	± 0.010	7.381	✓		"	
11.625	± "	11.625	✓		"	
0.38	± 0.030	0.372	✓		"	
3.081	± 0.010	3.085	✓		"	
17.73	± 0.030	17.75	✓		TAPE MEASURE	
19.34	"	19.34	✓		"	
φ 0.260	± 0.005 ± 0.001	0.260	✓		VCM	
0.30	± 0.010	0.308	✓		VCM	
φ 0.93	± 0.020	0.93	✓		VCM	

Measured by: E1	Audited by: [Signature]	Prototype Approval: N/A
Date: 06/09/26	Date: 06/09/26	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	